

Date: Wednesday, 03/06/2009 2:30:59 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206B UTILITY BASKET
Job Number :	45977		
Estimate Number :	11282		
P.O. Number :		Part Number :	D206540013
This Issue :	03/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D206-540/D2332-1 <i>11/09/06/03</i>
First Issue :	23/03/2009	Project Number :	N/A
Previous Run :	44222	Drawing Revision :	J
Written By :		Material :	
Checked & Approved By :		Due Date :	30/04/2009
Comment :	Est Rev:I Revised as per Rev I 05-12-07 JLM Est Rev:J reformat 06.04.04 EC Est Rev:K 07-03-20 As per DSI9361 JLM		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-013 CHG006



2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit



3.0	45977A	206B BASKET LID
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Comment: Sub-Component 206B BASKET LID

1 x D2330-043 Batch

B45977A

4.0	45977B	206B BASKET BASE
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Comment: Sub-Component 206B BASKET BASE

1 x D2330-041 Batch

B45977B

5.0	D2332041	Lid Prop Assembly 6.69" long
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y

B458 B45680

Date: Wednesday, 03/06/2009 2:30:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

N/A

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt

M108255

SS 09/06/04 (X)

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

M109798

SS 09/06/04 (X)

15.0

D27283

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Dart Logo label large

Batch:

B 22553

SS 09/06/04 (X)

16.0

AN422A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-22A

Bolt

M107715

SS 09/06/04

SS 09/06/04 (X)

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

M110625

SS 09/06/04 (X)

Date: Wednesday, 03/06/2009 2:30:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

8 AN960JD416 Washer

M110363x2

M111279x6

SS 09/06/04 (X1)

19.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110153

SS 09/06/04 (X1)

20.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M110523

SS 09/06/04 (X1)

21.0	D37231	Bushing
------	--------	---------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Batch: B47972

SS 09/06/04 (X1)

22.0	NAS43DD4 46N	Spacer
------	--------------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Spacer

Batch: M111886

SS 09/06/04 (X1)

23.0	AN420A	Bolt
------	--------	------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M16895

SS 09/06/04 (X1)

24.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer

M110704

SS 09/06/04 (X1)

Date: Wednesday, 03/06/2009 2:30:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD8

Washer

M110382

SS 09/06/04 (X)

26.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3)

M110399

SS 09/06/04 (X)

27.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

MS21042L4

Nut (or -4)

M109282 x4

M110450 x5

SS 09/06/04 (X)

28.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M109840

SS 09/06/04 (X)

29.0

D2258170

Label - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2258-170

Placard

B40487

SS 09/06/04 (X)

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

PK 09-06-01

Date: Wednesday, 03/06/2009 2:30:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/06/01

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

33.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2249-041 Braket

40486

88 09/06/04 (xc)

34.0

D33963

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Batch:

B36336

88 09/06/04 (xc)

35.0

D27497

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-7 Strut

B26887

88 09/06/04 (xc)

36.0

D2814

Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

B40901 x1

B38779 x1

88 09/06/04 (xc)

37.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

4 D2022-101 Spacer

B41928

88 09/06/04 (xc)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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38.0	D2012107	Clevis
------	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2012-107 Clevis

B33585

SS 09/06/04 (X)

39.0	D2259	Label
------	-------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

M10671

SS 09/06/04 (X)

40.0	D2525	Spacer
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

40151

SS 09/06/04 (X)

41.0	D2526	Bushing
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

39804

SS 09/06/04 (X)

42.0	D2748	Clevis
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

34511

SS 09/06/04 (X)

43.0	D27491	Strut
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1 Strut

40489

SS 09/06/04 (X)

44.0	D27493	Strut
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3 Strut

N/A

SS 09/06/04 (X)

Date: Wednesday, 03/06/2009 2:30:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

D2814

Strut



already in kit



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

B40901 X1 B38779 X1

46.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-12A

Bolt

M109754

SS 09/06/04 X1

47.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12 Bolt

M104016

SS 09/06/04 X1

48.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

M109061

SS 09/06/04 X1

49.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

M110625

SS 09/06/04 X1

50.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

M101390

SS 09/06/04 X1

Date: Wednesday, 03/06/2009 2:30:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

51.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

19 AN960JD416

Washer

M110363

SS 09/06/04 (X)

52.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516

Washer

M110523

SS 09/06/04 (X)

53.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4

Washer

M110704

SS 09/06/04 (X)

54.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M1109282

SS 09/06/04 (X)

55.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5

Nut

M1109840

SS 09/06/04 (X)

56.0

MS27039411

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11

Screw

M13355

SS 09/06/04 (X)

Date: Wednesday, 03/06/2009 2:30:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

57.0

AN46

Bolts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

M 9599

SS 09/06/04 (X)

58.0

AN3204

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

M 7195

SS 09/06/04 (X)

59.0

AN38022

Cotter Pins



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

M 10895

SS 09/06/04 (X)

60.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/06/04 (X)

61.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location:

PPP Rev:

9/6/04

SS 09/06/04 (X)

62.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/05 (X)

Job Completion



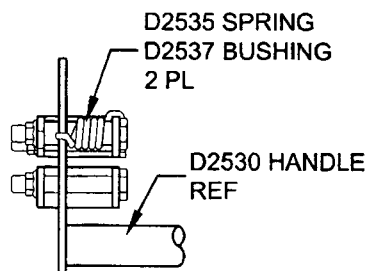
MF 09-06-04

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS
	4	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
1		D2749-5	STRUT
1	1	D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
4	4	D3396-3	SPACER
6	6	D3723-1	BUSHING
2	2	AN3-16A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
3	3	AN4-20A	BOLT
2	2	AN4-21A	BOLT
2	2	AN4-22A	BOLT
6	6	AN5-17A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
20	27	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
9	9	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27039-4-11	SCREW
3	3	NAS43DD4-46	SPACER

*NOTE: Placard D2259 to be installed in cockpit near the airspeed indicator.

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. J
MFG. APPR.	N/A	D206-540	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UTILITY BASKET INSTALLATION	NTS
DATE	09.02.09	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

w/o
45977



SPRING DETAIL

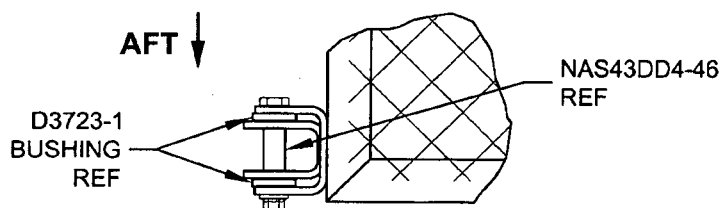
D2931 BUMPER
MS20600AD4W3 RIVET
AN960JD8 WASHER
4 PL

AN5-17A BOLT
AN960JD516 WASHER
MS21042L5 NUT
4 PL

AN3-16A BOLT
MS21042L3 NUT
2 PL

D2530 HANDLE

LATCH DETAIL



VIEW H-H: HINGE DETAIL

3 PL

OUTBOARD

BASKET LID
ASSEMBLY

AN4-22A BOLT
AN960JD416 WASHER
AN970-4 WASHER, 2X
MS21042L4 NUT
2 PL

AN4-20A BOLT
AN960JD416 WASHER
D3723-1 BUSHING
NAS43DD4-46
D372301 BUSHING
AN960JD416 WASHER
MS21042L4 NUT
3 PL

D2332-041 PROP
ASSEMBLY AFT
END ONLY

BASKET BASE
ASSEMBLY

PROP ARM & HINGE DETAIL

END VIEW, LOOKING FWD

DESIGN	KE	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. J
MFG. APPR.	N/A	D206-540	SHEET 8 OF 8
APPROVED	MM	TITLE	SCALE
DE APPR.		UTILITY BASKET INSTALLATION	NTS
DATE	09.02.09	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 45977
Estimate Number : 11282
P.O. Number :
This Issue : 23/03/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LARGE FAB ASSY
Previous Run : 44222
Written By :
Checked & Approved By : JUD 09.03.23
Comment : Est Rev:I Revised as per Rev I 05-12-07 JLM
Est Rev:J reformat 06.04.04 EC
Est Rev:K 07-03-20 As per DSI9361 JLM

Drawing Name : 206B UTILITY BASKET
Part Number : D206540013
Drawing Number : D206-540/DSI9361 UR
Project Number : N/A
Drawing Revision : I A
Material :
Due Date : 30/04/2009 Qty: 1 Um: Each

Additional Product

Job Number:



see attached

POSITIVE
RECALL

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-013 CHG008/5

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

3.0 45977A 206B BASKET LID



Comment: Sub-Component 206B BASKET LID

1 x D2330-043 Batch 45977A

4.0 45977B 206B BASKET BASE



Comment: Sub-Component 206B BASKET BASE

1 x D2330-041 Batch 45977B

5.0 D2332041 Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B45682

9/4/16

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER

B411928

SS 09/04/13 (X)

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment

B411928 46577

SS

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring

B45389

SS 09/04/13 (X)

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing

B45662

SS 09/04/13 (X)

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper

2139

SS 09/04/13 (X)

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet

M104715

SS 09/04/13 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A

Bolt

M108928 (2)

SS 09/04/13 (x)

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A

Bolt

M108255 (1)

SS 09/04/13 (x)

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A

Bolt

M109798

SS 09/04/13 (x)

15.0

D27283

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Dart Logo label large

Batch: 22553

SS 09/04/13 (x)

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A

Bolt

M107715 (x2)

SS 09/04/13 (x)

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A

Bolt

M110625 (x6)

SS 09/04/13 (x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer

M110363 x2 M111279 (x25)

SS 09/04/13 (x)

19.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M110153 - 2 from W/O.

SS 09/04/13 (x)

20.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M111279 (x2)

110523 x4

SS 09/04/13 (x)

21.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer

M110704 x4 M111724 (x1)

SS 09/04/13 (x)

22.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer

M110382

SS 09/04/13 (x)

23.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M110399

SS 09/04/13 (x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M109282 x4

M110450 x5

SS 09/04/13 @

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M109840 (x6)

SS 09/04/13 @

26.0

D2258170

Label - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2258-170

Placard

40482

SS 09/04/13 @

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

BR 09-06-10

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 09/06/10

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

09.06.01

marc B

30.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2249-041

Braket

40486

SS 09/04/13 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/04/17	27.0	Add spacer D3396-3 to workorder Batch: B36336 x6	PH	09/04/17			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D33963

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch: B36336

32.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

4 D2022-101 Spacer

4 B41928

33.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2012-107 Clevis

B3114 33585

34.0

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

M10671

35.0

D2525

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

40151

36.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

39804

37.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

34511

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

D27491

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1 Strut

40489

39.0

D27493

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3 Strut

B40899

took out

40.0

D2814

Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

B40901 x1 B38779 x1

41.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

M109754

42.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12 Bolt

409754 M104016

43.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

M109005

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/6/13	# 39.0	Parent Change Part should be 2745-7 due to new change #. Replace D2745-3 For D2745-7					<i>C. Corliss</i>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

M110625

SS 09/04/13 (X)

45.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

101390

SS 09/04/13 (X)

46.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

19 AN960JD416

Washer

M110363

(PB) →

SS 09/04/13 (X)

47.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

M110523

SS 09/04/13 (X)

48.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4 Washer

M110704

SS 09/04/13 (X)

49.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch


4 MS21042L4

Nut (or -4)

109282

SS 09/04/13 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/6/13	#46.0	Permanet change Qty of A1960 SD416 is should be 23 Due to new change to					 02/06/13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

50.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

109840

51.0	MS27039411	Screw
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11 Screw

M3355

52.0	AN46	Bolts
------	------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

109545 M9599

53.0	AN3204	Nut
------	--------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

M7195

54.0	AN38022	Cotter Pins
------	---------	-------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

M116895

55.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

56.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location: _____

PPP Rev: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45977

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
KE	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 1
		D206-540	SHEET 1 OF 8
DATE	TITLE		SCALE
05.11.10	UTILITY BASKET INSTALLATION		NTS
C	94.07.28	REVISED DRAWING	
D	94.11.12	ADDED D2323 STRUT	
E	94.11.12	CHANGED SECTION C-C	
F	94.11.12	ADDED HANDLE AND LID PROP	
G	99.09.21	REDRAW, CHANGE LATCH/HINGE/STRUTS	
H	99.12.02	INCORPORATE DSI 9174 / DEO 9167	
I	05.11.10	REPLACED PIANO HINGE SYSTEM	

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS
2	6	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
	1	D2749-3	STRUT
1		D2749-5	STRUT
1		D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
2	2	AN3-16A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
2	2	AN4-21A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
2	2	AN4-7A	BOLT
6	6	AN5-17A	BOLT
16	23	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
8	8	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27039-4-11	SCREW

*NOTE: Placard D2259 to be installed in cock pit near the airspeed indicator.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45977

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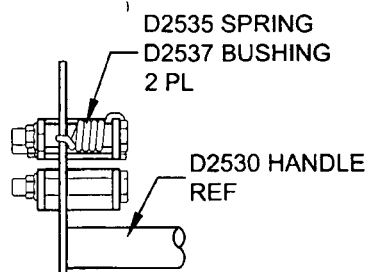
Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS <i>kit</i> ✓
	4	D2022-101	SPACER <i>kit</i> 2 <i>2 installed</i>
2	2	D2249-041	BRACKET <i>kit</i> ✓
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD <i>installed</i>
1	1	D2259	PLACARD* ✓
	1	D2330-041	BASKET ASSEMBLY <i>installed</i>
	1	D2330-043	LID ASSEMBLY <i>installed</i>
1	1	D2332-041	LID PROP ASSEMBLY <i>installed</i>
2	2	D2525	SPACER KIT <i>kit</i>
2	2	D2526	BUSHING <i>kit</i>
1	1	D2530	HANDLE WELDMENT <i>installed</i>
2	2	D2535	SPRING <i>installed</i>
2	2	D2537	BUSHING <i>installed</i>
2	2	D2748	CLEVIS <i>kit</i>
	1	D2749-1	STRUT <i>kit</i>
1		D2749-5	STRUT
1	1	D2749-7	STRUT ?
	2	D2814	STRUT <i>kit</i>
4	4	D2931	BUMPER <i>installed</i>
4	4	D3396-3	SPACER ✓
6	6	D3723-1	BUSHING ?
2	2	AN3-16A	BOLT <i>installed</i>
8	8	AN4-5A	BOLT <i>kit</i>
	1	AN4-6	BOLT <i>kit</i>
	2	AN4-12	BOLT <i>kit</i>
2	2	AN4-12A	BOLT <i>kit</i>
3	3	AN4-20A	BOLT ? <i>installed</i>
2	2	AN4-21A	BOLT <i>kit</i>
2	2	AN4-22A	BOLT <i>installed</i>
6	6	AN5-17A	BOLT <i>x2 kit</i> <i>4 installed</i>
	3	AN320-4	NUT <i>kit</i>
	3	AN380-2-2	COTTER PIN <i>kit</i>
20	27	AN960JD416	WASHER <i>x19 kit</i> <i>4 installed</i> <i>missing (x5)</i>
6	6	AN960JD516	WASHER <i>x22 kit</i> <i>4 installed</i>
4	4	AN960JD8	WASHER <i>installed</i>
4	5	AN970-4	WASHER <i>x1 kit</i> <i>4 installed</i> <i>missing</i>
4	4	MS20600AD4W3	RIVET <i>installed</i>
2	2	MS21042L3	NUT (OR MS21042-3) <i>installed</i>
9	9	MS21042L4	NUT (OR MS21042-4) <i>(x4)</i> <i>x4 installed</i>
6	6	MS21042L5	NUT (OR MS21042-5) <i>(x2)</i> <i>x4 installed</i>
	1	MS27039-4-11	SCREW <i>kit</i>
3	3	NAS43DD4-46	SPACER ? <i>installed</i>

REFERENCE ONLY

45977

*NOTE: Placard D2259 to be installed in cockpit near the airspeed indicator.

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JB</i>		
CHECKED	<i>Ad</i>	DRAWING NO.	REV. J
MFG. APPR.	N/A	D206-540	SHEET 2 OF 8
APPROVED	<i>AM</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	UTILITY BASKET INSTALLATION	NTS
DATE	09.02.09	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SPRING DETAIL

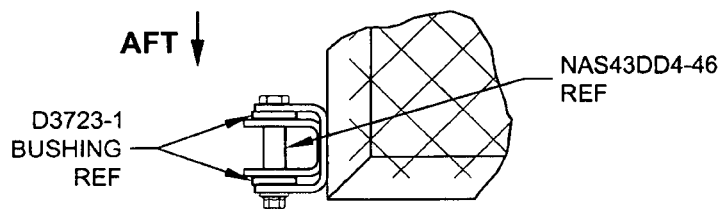
D2931 BUMPER
MS20600AD4W3 RIVET
AN960JD8 WASHER
4 PL

AN5-17A BOLT
AN960JD516 WASHER
MS21042L5 NUT
4 PL

AN3-16A BOLT
MS21042L3 NUT
2 PL

D2530 HANDLE

LATCH DETAIL



VIEW H-H: HINGE DETAIL
3 PL

REFERENCE ONLY

OUTBOARD
→

BASKET LID
ASSEMBLY

AN4-22A BOLT
AN960JD416 WASHER
AN970-4 WASHER, 2X
MS21042L4 NUT
2 PL

AN4-20A BOLT
AN960JD416 WASHER
D3723-1 BUSHING
NAS43DD4-46
D372301 BUSHING
AN960JD416 WASHER
MS21042L4 NUT
3 PL

H ↓ H ↓

D2332-041 PROP
ASSEMBLY AFT
END ONLY

BASKET BASE
ASSEMBLY

45977

PROP ARM & HINGE DETAIL
END VIEW, LOOKING FWD

DESIGN	KE	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. J
MFG. APPR.	N/A	D206-540	SHEET 8 OF 8
APPROVED	JMP	TITLE	SCALE
DE APPR.		UTILITY BASKET INSTALLATION	NTS
DATE	09.02.09	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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Date : Monday, 25/05/2009 11:23:28 AM

User : Eric Charbonneau

ESTIMATING - DETAIL QUOTATION

Estimate No.	: 11282	Date Entered	: 07/12/2005
Customer	: CU-DAR001 Dart Helicopters Services	SLS Person	:
R.F.Q. Number	: CHG 006	Target Date	: 07/12/2005
Part Number	: D206540013	Accepted	: 20/12/2005
Drawing Name	: 206B UTILITY BASKET	Last Job No.	: 45977
Project #	: N/A	Class	: DAFABL
Drawing #	: D206-540 REV J		
Quantities	: Each	1	0
Scrap Allowed	:	0.00	0.00
Material	:		
Comment	Est Rev:I Revised as per Rev I 05-12-07 JLM Est Rev:J reformat 06.04.04 EC Est Rev:K 07-03-20 As per DSI9361 JLM Est Rev L 09.04.28 per D206-540 rev J EC verified by:DD		
#	DESCRIPTION	TYPE	DETAIL : Cost Per Unit * Units (Sub-Com., Inv. Item, Ext OP.) TOTAL COST \$ 1/0.00 0/0.00 0/0.00 0/0.00
1	917 DC	Int. OP.	S: 0.00h/R: 0.00h \$0.00
	Comment DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD206-540-013 CHG006		
2	711 PACKAGING 1	Int. OP.	S: 0.00h/R: 0.00h \$0.00
	Comment PACKAGING RESOURCE #1 Pick: Assembly Kit		
3	11280 D2330043	Sub-Com.	\$229.31*1.00 \$229.31
	Comment 206B BASKET LID 1 x D2330-043 Batch <u>B45977A</u>		
4	11276 D2330041	Sub-Com.	\$446.47*1.00 \$446.47
	Comment 206B BASKET BASE 1 x D2330-041 Batch <u>B45977B</u>		
5	D2332041	Inv. Item	\$0.00*1.00 \$0.00
	Comment Pick: Assembly Kit Qty Part Number Description Batch 1 D2332-041 Prop Ass'y <u>B45682</u> 4.00		
6	D2022101	Inv. Item	\$0.38*2.00 \$1.52
X	Comment Pick: Assembly Kit Qty Part Number Description Batch 2 D2022-101 SPACER <u>B41928</u>		

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ESTIMATING - DETAIL QUOTATION

Estimate No. : 11282

Part Number

: D206540013

#	DESCRIPTION	TYPE	DETAIL Cost Per Unit * Units (Sub-Com., Inv. Item, Ext OP.)		OR Setup (hrs)/Run(hrs)		(Int.OP.)
			TOTAL COST \$				
			1/0.00	0/0.00	0/0.00	0/0.00	
7	D2530	Inv. Item	\$0.00*1.00				
			\$0.00				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 1 D2530 Handle Weldment <u>B346579.</u>						
8	D2535	Inv. Item	\$3.19*2.00				
			\$6.38				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 2 D2535 Spring <u>B45389.</u>						
9	D2537	Inv. Item	\$0.00*2.00				
			\$0.00				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 2 D2537 Bushing <u>B45662.</u>						
10	D2931	Inv. Item	\$0.00*4.00				
			\$0.00				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 4. D2931 Bumper <u>B21139</u>						
11	MS20600AD4W3	Inv. Item	\$0.00*4.00				
			\$0.00				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 4 MS20600AD4W3 Rivet <u>m104715.</u>						
12	AN424A	Inv. Item	\$0.36*1.00				
			\$0.36				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 1 AN4-24A Bolt _____						
13	AN316A	Inv. Item	\$0.00*2.00				
			\$0.00				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 2 AN3-16A Bolt <u>m109798</u>						
14	D27283	Inv. Item	\$0.56*0.00				
			\$0.00				
	Comment Dart Logo label large Batch: <u>B22553</u>						
15	AN422A	Inv. Item	\$0.00*2.00				
			\$0.00				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 1 AN4-22A Bolt <u>m107715.</u>						

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Part Number

: D206540013

#	DESCRIPTION	TYPE	DETAIL Cost Per Unit * Units (Sub-Com., Inv. Item, Ext OP.)	OR Setup (hrs)/Run(hrs)		(Int. OP.)
			TOTAL COST \$			
			1/0.00	0/0.00	0/0.00	0/0.00
16	AN517A	Inv. Item	\$0.00*4.00			
			\$0.00			
Comment Pick: Assembly Kit Qty Part Number Description Batch 4 AN5-17A Bolt <u>m110625.</u>						
17	AN960JD416	Inv. Item	\$0.03*6.00 ✓			
			\$0.26			
Comment Pick: Assembly Kit Qty Part Number Description Batch 4 AN960JD416 Washer <u>m110363.</u>						
18	AN960JD416L	Inv. Item	\$0.11*2.00 ✓			
			\$0.21			
Comment Washer <u>m110153.</u>						
19	AN960JD516	Inv. Item	\$0.00*4.00			
			\$0.00			
Comment Pick: Assembly Kit Qty Part Number Description Batch 4 AN960JD516 Washer <u>m110523.</u>						
20	AN9704	Inv. Item	\$0.00*4.00			
			\$0.00			
Comment Pick: Assembly Kit Qty Part Number Description Batch 4 AN970-4 Washer <u>m110704</u>						
21	AN960JD8	Inv. Item	\$0.02*4.00			
			\$0.08			
Comment Pick: Assembly Kit Qty Part Number Description Batch 4 AN960JD8 Washer <u>m110382.</u>						
22	MS21042L3	Inv. Item	\$0.00*2.00			
			\$0.00			
Comment Pick: Assembly Kit Qty Part Number Description Batch 2 MS21042L3 Nut (or -3) <u>m110399.</u>						
23	MS21042L4	Inv. Item	\$0.00*9.00			
			\$0.00			
Comment Pick: Assembly Kit Qty Part Number Description Batch 4 MS21042L4 Nut (or -4) <u>m109282.</u>						

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ESTIMATING - DETAIL QUOTATION

Estimate No. : 11282

Part Number

: D206540013

#	DESCRIPTION	TYPE	DETAIL	Cost Per Unit * Units	(Sub-Com., Inv. Item, Ext OP.)	OR	Setup (hrs)/Run(hrs)	(Int. OP.)
			TOTAL COST \$					
				1/0.00	0/0.00		0/0.00	0/0.00
24	MS21042L5	Inv. Item		\$0.00*4.00				
				\$0.00				
	Comment Pick: Assembly Kit Qty Part Number Description Batch 4 MS21042L5 Nut (or -5) <i>m 109840</i>							
25	D2258170	Inv. Item		\$5.60*1.00				
				\$5.60				
	Comment Pick: Qty Part Number Description Batch 1 D2258-170 Placard <i>B40437</i>							
26	D37231	Inv. Item		\$4.84*6.00				
				\$29.03				
	Comment Bushing <i>B57972</i>							
27	NAS43DD4 468	Inv. Item		\$0.00*3.00				
				\$0.00				
	Comment Spacer <i>m 111886</i>							
28	AN420A	Inv. Item		\$0.26*3.00				
				\$0.79				
	Comment Bolt <i>m 16895</i>							
29	111 SMALL FAB 1	Int. OP.		S: 0.00h/R: 0.00h				
				\$0.00				
	Comment SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D206-540							
30	919 QC5	Int. OP.		S: 0.00h/R: 0.00h				
				\$0.00				
	Comment INSPECT WORK TO CURRENT STEP							
31	711 PACKAGING 1	Int. OP.		S: 0.00h/R: 0.00h				
				\$0.00				
	Comment PACKAGING RESOURCE #1 Pick: Packing Kit							
32	D2249041	Inv. Item		\$44.77*2.00				
				\$89.54				
	Comment Pick: Packing Kit 2 D2249-041 Braket							
33	D33963	Inv. Item		\$6.64*4.00				
				\$26.55				
	Comment Spacer Batch:							
34	D2022101	Inv. Item		\$0.38*4.00				
				\$1.52				
	Comment Pick: Packing Kit 4 D2022-101 Spacer <i>B.41928</i>							

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ESTIMATING - DETAIL QUOTATION

Estimate No. : 11282

Part Number

: D206540013

#	DESCRIPTION	TYPE	DETAIL	Cost Per Unit * Units	(Sub-Com., Inv. Item, Ext OP.)	OR	Setup (hrs)/Run(hrs)	(Int. OP.)
			TOTAL COST \$					
				1/0.00	0/0.00		0/0.00	0/0.00
35	D2012107	Inv. Item		\$2.99*1.00				
				\$2.99				
	Comment Pick: Packing Kit 1 D2012-107 Clevis							
36	D2259	Inv. Item		\$0.50*1.00				
				\$0.50				
	Comment Pick: Packing Kit 1 D2259 Placard							
37	D2525	Inv. Item		\$7.10*2.00				
				\$14.20				
	Comment Pick: Packing Kit 2 D2525 Spacer kit							
38	D2526	Inv. Item		\$2.67*2.00				
				\$5.34				
	Comment Pick: Packing Kit 2 D2526 Bushing							
39	D2748	Inv. Item		\$4.66*2.00				
				\$9.32				
	Comment Pick: Packing Kit 2 D2748 Clevis							
40	D27491	Inv. Item		\$8.09*1.00				
				\$8.09				
	Comment Pick: Packing Kit 1 D2749-1 Strut							
41	D27497	Inv. Item		\$25.76*1.00				
				\$25.76				
	Comment Pick: Packing Kit 1 D2749-7 Strut							
42	D2814	Inv. Item		\$5.74*2.00				
				\$11.48				
	Comment Pick: Packing Kit 2 D2814 Strut							
43	AN412A	Inv. Item		\$0.00*2.00				
				\$0.00				
	Comment Pick: Packing Kit Qty Part Number Description Batch 2 AN4-12A Bolt							
44	AN412	Inv. Item		\$0.86*2.00				
				\$1.72				
	Comment Pick: Packing Kit 2 AN4-12 Bolt							

Date : Monday, 25/05/2009 11:23:29 AM

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ESTIMATING - DETAIL QUOTATION

Estimate No. : 11282

Part Number

: D206540013

#	DESCRIPTION	TYPE	DETAIL	Cost Per Unit * Units	(Sub-Com., Inv. Item, Ext OP.)	OR Setup (hrs)/Run(hrs)	(Int. OP.)
			TOTAL COST \$				
			1/0.00	0/0.00	0/0.00	0/0.00	
45	AN45A	Inv. Item	\$0.19*8.00				
			\$1.52				
	Comment Pick: Packing Kit 8 AN4-5A Bolt						
46	AN517A	Inv. Item	\$0.30*2.00				
			\$0.60				
	Comment Pick: Packing Kit 2 AN5-17A Bolt						
47	AN421A	Inv. Item	\$0.33*2.00				
			\$0.66				
	Comment Pick: Packing Kit 2 AN4-21A Bolt						
48	AN960JD416	Inv. Item	\$0.00*19.00				
			\$0.00				
	Comment Pick: Packing Kit Qty Part Number Description Batch 19 AN960JD416 Washer						
49	AN960JD516	Inv. Item	\$0.06*2.00				
			\$0.12				
	Comment Pick: Packing Kit 2 AN960JD516 Washer						
50	AN9704	Inv. Item	\$0.24*1.00				
			\$0.24				
	Comment Pick: Packing Kit 1 AN970-4 Washer						
51	MS21042L4	Inv. Item	\$0.00*4.00				
			\$0.00				
	Comment Pick: Packing Kit Qty Part Number Description Batch 4 MS21042L4 Nut (or -4)						
52	MS21042L5	Inv. Item	\$0.30*2.00				
			\$0.60				
	Comment Pick: Packing Kit 2 MS21042L5 Nut						
53	MS27039411	Inv. Item	\$0.15*1.00				
			\$0.15				
	Comment Pick: Packing Kit 1 MS27039-4-11 Screw						

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ESTIMATING - DETAIL QUOTATION

Estimate No. : 11282

Part Number : D206540013

#	DESCRIPTION	TYPE	DETAIL	Cost Per Unit * Units	(Sub-Com., Inv. Item, Ext OP.)	OR	Setup (hrs)/Run(hrs)	(Int. OP.)
			TOTAL COST \$					
				1/0.00			0/0.00	0/0.00
54	AN46	Inv. Item		\$0.37*1.00				
				\$0.37				
	Comment Pick: Packing Kit 1 AN4-6 Bolt							
55	AN3204	Inv. Item		\$1.04*3.00				
				\$3.12				
	Comment Pick: Packing Kit 3 AN320-4 Nut							
56	AN38022	Inv. Item		\$0.03*3.00				
				\$0.09				
	Comment Pick: Packing Kit 3 AN380-2-2 Cotter pin							
57	922 QC4	Int. OP.		S: 0.00h/R: 0.00h				
				\$0.00				
	Comment INSPECT 100% KITS FOR COMPLETENESS							
58	711 PACKAGING 1	Int. OP.		S: 0.00h/R: 0.00h				
				\$0.00				
	Comment PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D206-540-013 Location: _____ PPP Rev: _____							
59	1012 QC21	Int. OP.		S: 0.00h/R: 0.00h				
				\$0.00				
	Comment FINAL INSPECTION/W/O RELEASE							

Date : Monday, 25/05/2009 11:23:29 AM

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ESTIMATING - DETAIL QUOTATION

Estimate No. : 11282

Part Number : D206540013

Total Time	0.00			
Sub Components	\$675.78			
Material Cost	\$248.72			
Setup Cost	\$0.00			
Run Cost	\$0.00			
Scrap Run Cost	\$0.00			
Sub-Contract Cost	\$0.00			
Total Cost	\$924.50			
Cost Per Unit	\$924.50			
Markup Material	67.00%			
Markup Shop/OP.	67.00%			
Markup Subcontract	67.00%			
Currency Exchange USD	1.2000			
Quoted /Unit	\$1,543.91			
Final Each	\$1,286.60			
Final Quoted	\$1,286.60			
Gross Profit	40.12%			
Sent Via :	On : / /	By :	To :	
Written by _____	Approved by _____	Delivery _____	Date _____	

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1 ✓	D2012-107	CLEVIS
	4 ✓	D2022-101	SPACER
2	2 ✓	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1 ✓	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2 ✓	D2525	SPACER KIT
2	2 ✓	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2 ✓	D2748	CLEVIS
	1 ✓	D2749-1	STRUT
1		D2749-5	STRUT
1	1	D2749-7	STRUT
	2 ✓	D2814	STRUT
4	4	D2931	BUMPER
4	4 ✓	D3396-3	SPACER
6	6	D3723-1	BUSHING
2	2	AN3-16A	BOLT
8	8 ✓	AN4-5A	BOLT
	1 ✓	AN4-6	BOLT
	2 ✓	AN4-12	BOLT
2	2 ✓	AN4-12A	BOLT
3	3	AN4-20A	BOLT
2	2 ✓	AN4-21A	BOLT
2	2	AN4-22A	BOLT
6	6 ✓	AN5-17A	BOLT
	3 ✓	AN320-4	NUT
	3 ✓	AN380-2-2	COTTER PIN
20	27	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
9	9	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1 ✓	MS27039-4-11	SCREW
3	3	NAS43DD4-46	SPACER

*NOTE: Placard D2259 to be installed in cockpit near the airspeed indicator.

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	3		
CHECKED	PA	DRAWING NO.	REV. J
MFG. APPR.	N/A	D206-540	SHEET 2 OF 8
APPROVED	AM	TITLE	SCALE
DE APPR.	TH	UTILITY BASKET INSTALLATION	NTS
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